

Date: Monday, 13/04/2009 8:22:41 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 47122	
Estimate Number : 13052	
P.O. Number :	Part Number : D36704200
This Issue : 13/04/2009 S.O. No. :	Drawing Number : D3670 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 46106	Material :
Written By :	Due Date : 22/04/2009 Qty : 40 Um : Each
Checked & Approved By : <u>JULIE DAWSON</u>	
Comment : Est Rev A new issue 07-10-30 DD verified by: Est Rev:B Ecn 1056 Rev A dwg DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T03125W058	ALUM TUBE .3125 x .058w
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**Comment:** Qty.: 0.3675 f(s)/Unit Total : 14.7000 f(s)

Material:

(M6061T6T0.313W.058)

Batch:

1147009.05.04

2.0

~~HARDINGE~~DOOSAN

HARDINGE CNC LATHE SMALL

**Comment:** 1-TURN AS PER FOLIO FA711 & DWG D3670FOLIO REV: ADWG REV: A

2-DEBURR AS REQUIRED

09.05.04

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE09.05.04 (40)

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK09/05/04

5.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location:

Forley09/05/04 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 47122

Part Number: D36704200

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

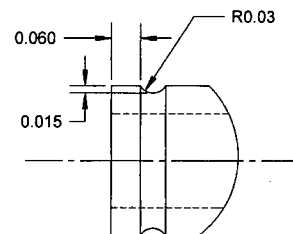
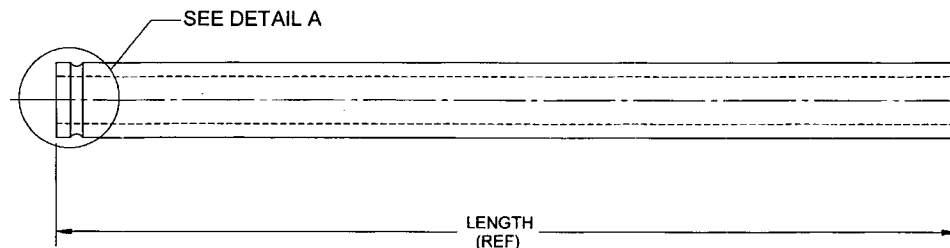
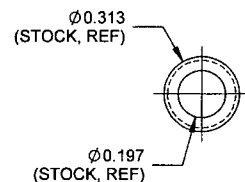
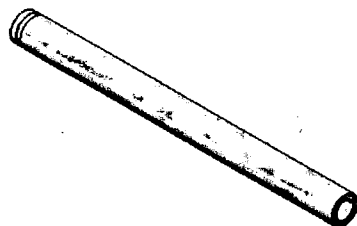
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

RELEASED
07.11.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T9-0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SHOT COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

A		NEW ISSUE		DC	07.10.19
REV.		DESCRIPTION		BY	DATE
DESIGN		<div><div>DC</div><div>DF</div><div>BO</div><div>WJ</div></div> <div>DART AEROSPACE LTD</div> <div>HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D3670</div> <div>TITLE SPACER</div> <div>SCALE 2:</div> <div><div>COPYRIGHT © 2007 BY DART AEROSPACE LTD</div><div>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</div></div>			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE 07.10.19		SHEET 1 OF 1			